

Date: Friday, 18/07/2008 1:09:57 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI ACCESS HANDLE WELDMENT ASS'Y, RH
Job Number	: 40638		
Estimate Number	: 10947		
P.O. Number	:	Part Number	: D2480012
This Issue	: 18/07/2008	Drawing Number	: D2480 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: A1
Previous Run	: 38293	Material	:
Written By	:	Due Date	: 10/08/2008
Checked & Approved By	: <u>JUL 08 7.18</u>	Qty:	4 Um: Each
Comment	: Est. C1 03.01.09 Added Powder Coat		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2478	Heli-Access Handle
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Lower Arm

Pick:

Qty	Part number	Description	Batch
1	D2478	Heli Access Handle	B34632✓

Pl 08-08-14

2.0	D2479	Heli-Access Handle
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Upper Arm

Pick:

Qty	Part number	Description	Batch
1	D2479	Heli Access Handle	B40633✓

Pl 08-08-14

3.0	D2481	Mounting Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Lower Mount Plate

Pick:

Qty	Part number	Description	Batch
2	D2481	Mounting Plate	B40888✓

Pl 08-08-14

4.0	D2482	Mounting Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Upper Mount Plate

Pick:

Qty	Part number	Description	Batch
1	D2482	Mounting Plate	B38319✓

Pl 08-08-14
 3✓ B38319 → 1✓

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 18/07/2008 1:09:57 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS HANDLE WELDMENT ASS'Y, RH

Job Number: 40638

Part Number: D2480012

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Template DT 8333 (DT 2480 CJ)

Pl 08.08.14

(X4)

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/08/14 (4)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/14 (4)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:30
400°F
12:00

M.A. 08/08/18

(4X)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8/8/18

(4X) SC

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

40614

8/8/18

(4X)

SC

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/20

Job Completion



W 08-18

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

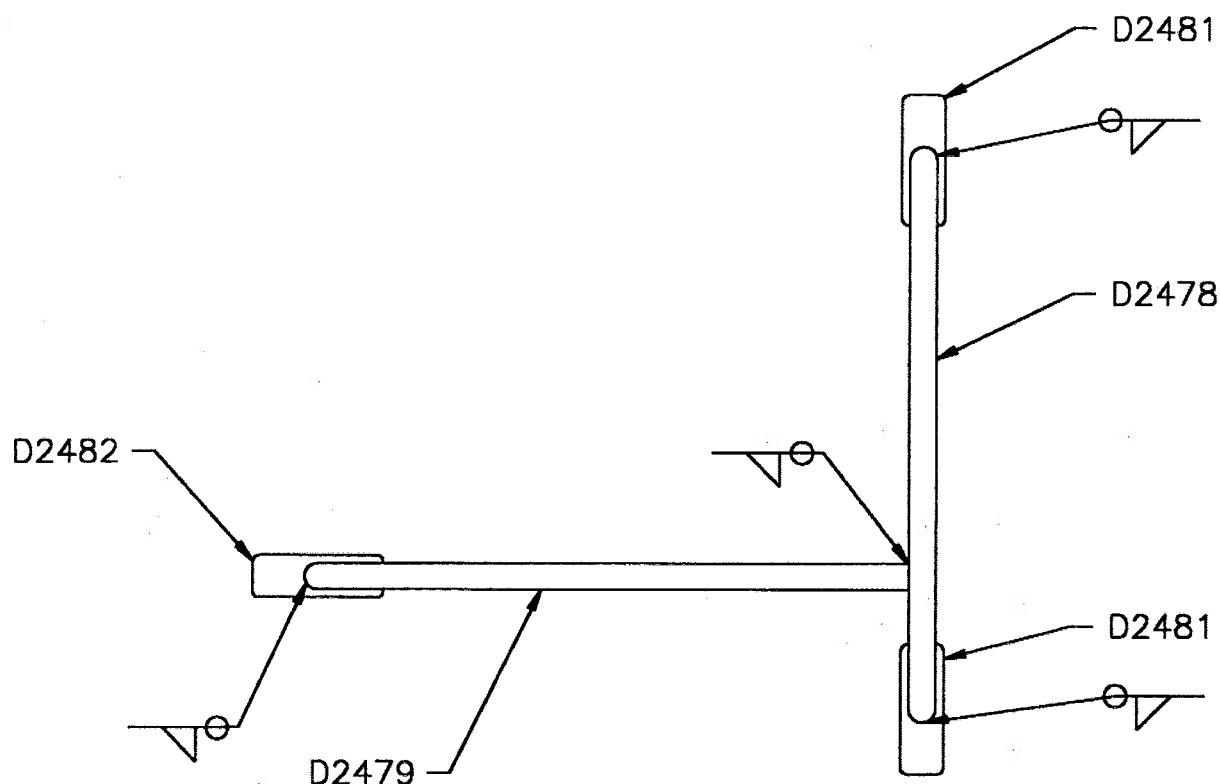
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN B WILLIAMS	DRAWN BY MIKE M	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2480	REV. A SHEET 1 OF 1
DATE 96:05:14		TITLE HANDLE WELDMENT ASSEMBLY	SCALE 6:1
A1 <i>05.06.23</i>		ADDED POWDER COAT	

RELEASED
96/10/02 DS



D2480-011 LH SHOWN
D2480-012 RH OPPOSITE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *49038*

NOTES:

- 1) WELD PER TEMPLATE DT 2480 WG PER QSI 004
A1 2) POWDER COAT WHITE GLOSS (REF: 4,3,5,2) AS PER QSI 005